



NOTES:

1) MATERIAL: -041/-042: MAKROLON/TUFFAK UC/GP, CLEAR, 0.177" THICK
REF DART SPEC MPOLYS.177-01
-043/-044: MAKROLON/TUFFAK OP, BRONZE #5109, 0.187" THICK
REF DART SPEC MPOLYS.187-02

2) FINISH: APPLY LPI AEROCOAT 107P HARDCOAT (BOTH SIDES)
INSTALL LPI 9149 EDGE ATTACHMENT USING PR1425 PER "D5621-041 CF" (LH) OR "D5621-042 CF" (RH)
IT IS ACCEPTABLE TO SPLICE EDGE ATTACHMENT BETWEEN HOLES.
INNER AND OUTER SPLICES MUST BE AT LEAST ONE HOLE SPACING APART

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: ALL TRIMMED SURFACES MUST HAVE ¹²⁵ FINISH

6) IDENTIFICATION: SANDBLAST IDENTIFICATION USING 0.125" LETTERS IN LOCATION SHOWN (MAX 0.005" DEEP):
D5621-04X (P/N) SN XXX (S/N)
XX-20YY (DATE) 3AL64 (CAGE CODE)

7) WEIGHT: 6.40 - 7.25 LBS

8) FORM PER LPI PROCESS "D5621" USING LPI FORMING TOOL "D5621-041 FM" (LH) OR "D5621-042 FM" (RH) RESPECTIVELY

9) TRIM PER LPI TRIMMING TOOL "D5621-041 TF" (LH) OR "D5621-042 TF" (RH) RESPECTIVELY

10) EXTREME CARE MUST BE TAKEN NOT TO DAMAGE THE SURFACE OF THE WINDOW

11) DRILL Ø0.375 HOLE ON -042/-044 PER LPI TRIMMING TOOL "D5621-042 TF"

12) ACCEPTANCE CRITERIA:
A) MINIMUM THICKNESS AFTER FORMING IS 0.150"
B) CONTOUR: MUST FIT FORMING TOOLS WITH A MAX GAP OF 0.060" AT THE TRIM LINE WHEN
NO MORE THAN 4X 4 LB WEIGHTS ARE EQUALLY SPACED ON THE PERIMETER
C) DISTORTION: INSPECTOR TO VIEW THRU PART. NO MORE THAN 3X 0.060" DEFECTS IN A CIRCLE WITH A 6.77" RADIUS.
WINDOW MUST BE GENERALLY PARALLEL EXCEPT FOR WITHIN 1" OF THE WINDOW PERIMETER, WHICH IS NON-OPTICAL

D5621-042/-044 SKYLIGHT WINDOW, RH

RELEASED
2019 JAN 11
ECN 19-304

APPROVED

C	REVISED NOTE 1	VS	19.01.07
B	ADDED 0.063" AROUND PERIMETER FOR INCREASED EDGE DISTANCE WHEN TRANSFER DRILLING	VS	18.07.25
A	NEW ISSUE	VS	18.02.21
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RA	D5621	SHEET 1 OF 1
APPROVED	VS	TITLE	SCALE
DE APPR.	DS	SKYLIGHT WINDOW	NTS
DATE	19.01.07	COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	